

Work Order ID 128817

Tuesday, January 27, 2015 7:48:46 AM

128817

Page 1

Item ID: D2647 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cap
 Start Date: 1/26/15 Start Qty: 16.00 ***16*** Cust Item ID:
 Required Date: 1/26/15 Req'd Qty: 16.00 ***16*** Customer:
 Reference:

Approvals: Process Plan: MCS Date: 1-29-29 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2647	Rev F								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2647								
<u>6061.080</u>	Dwg Rev: <u>F</u>								
	Prog Rev: <u>F</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

30 0 Jm 15-2-10

30 0 Jm 15-2-10

30 0 Jm 15-2-10

DAS
38
9-89

FEB 11 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab Small Fab	Small Fab Memo Deburr N/A DAS 38 9-89	0.00 0.00							
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo N/A DAS 38 9-89	0.00 0.00							
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>LG</u> Memo ***STOCK IN SKIDTUBE CELL***	0.00 0.00							

30 0 BE15-02-17

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Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence
		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
		☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cap

Start Date: 1/26/15 Start Qty: 16.00

16

Cust Item ID:

Required Date: 1/26/15 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

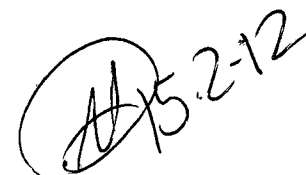
QC

Memo

0.00

Quality Control

ML5 1502-18



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Picklist Print

Tuesday, January 27, 2015 7:48:46 AM

Page 1

Work Order ID: 128817

128817

Parent Item: D2647

D2647

Parent Item Name: Cap

Start Date: 1/26/15

Required Date: 1/26/15

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP Rev:D99.01.25Re-formatDM
IPP: E 06.11.15 waterjet EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		100	sf	280.1168	0.1597	2.689685			
M6061T6S 080									**	(4)		Jm15-2-10	
6061-T6 .080 Sheet													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT020	280.1168						
						m130530	67						
						m130560	213.1168						
										130560.			

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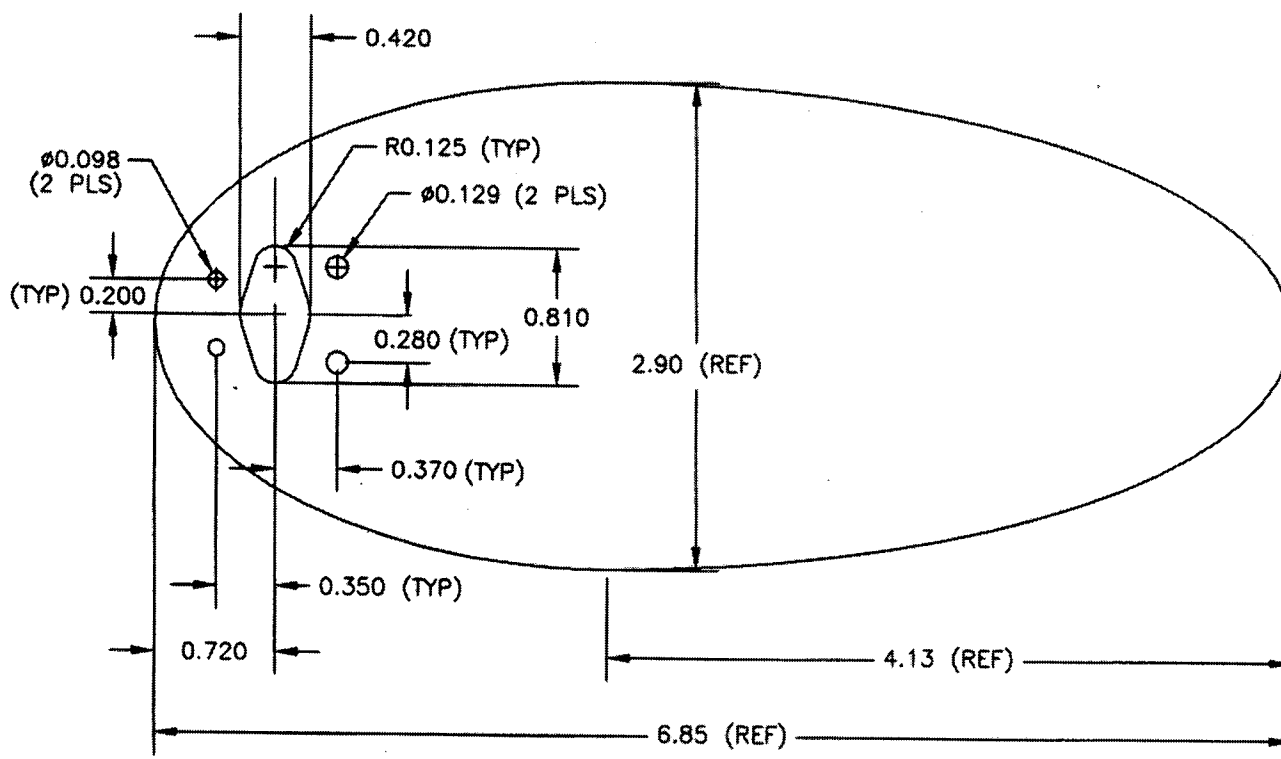
FAULT CATEGORY

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DESIGN #	DRAWN BY RT	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED #	APPROVED #	DRAWING NO. D2647	REV. F SHEET 1 OF 1
DATE 00.05.26		TITLE CAP	SCALE NTS
A	97.03.25	NEW ISSUE	
B	97.06.27	CHANGED SHAPE	
C	97.09.15	REMOVE FRONT PLATE	
D	97.11.06	ADD RIVET HOLES	
E	98.01.15	ADD 5052 MATERIAL (TSR A245)	
F	00.05.26	MAKE FROM D2794	

RELEASED
00.06.09



THIS PART CAN BE MADE FROM D2794

MATERIAL: 6061-T6 (QQ-A-250/11) OR 5052-H32 (QQ-A-250/8) 0.080 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

128817
150129
MCH

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